

CUSTOM TEXTURED

Work Order ID 124684

124684

Page 1

September-22-14 9:43:12 AM

Item ID: D3874-2L02 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Floor Protector, Pilot (Black)
 Start Date: 9/22/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 9/26/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3874	B

100		0.00							
100									
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	1-Cut Sheet to required Blank size								

SEP 22 2014

DAS
24
9-89

105		0.00							
105									
HandThermo	Dry Material	0.00							
Hand Finishing Thermoforming	Memo	0.00							
	Dry Sheet as per QSI022 POLYCARBONATE								

DAS
07
9-89

Temp: 245 deg. F SEP 23 2014
 Time IN: 5:00 PM
 Time OUT: 5:00 AM Per... W.H.

14/09/23

Page 2

[illegible]

Work Order ID 124684***124684***

Page 3

September-22-14 9:43:12 AM

Item ID: D3874-2L02

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Floor Protector, Pilot (Black)

Start Date: 9/22/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/26/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

1
DAS
38
9-89 14-9-23

170

Identify as per dwg & Stock Location: _____

0.00

170

Packaging

Memo

PPP124682

0.00

Packaging

1 14/9/23
DAS
32
9-89

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

MLS 14-09-24

14-9-23

Picklist Print

September-22-14 9:43:12 AM

Page 1

Work Order ID: 124684

124684

Parent Item: D3874-2L02

D3874-2L 02

Parent Item Name: Floor Protector, Pilot (Black)

Start Date: 9/22/14

Required Date: 9/26/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev A Added color code to D3874-2 14/07/02 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F6006-02		Purchased	No			100	sf	2,174.880	4.38	5			DAS 07 9-89
MI FXS 125-F6006-02									**				
GE PLASTICS LEXAN SHEET(BLACK)													

Location

Loc Qty

Loc Code

MAT018

4.3

m128887

4.3

waterjet

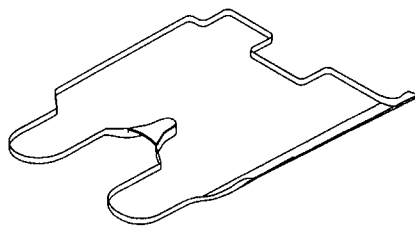
2170.58

(m128887)

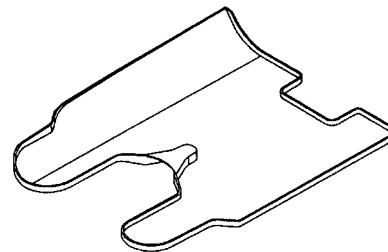
2170.58

14/09/23

5 59 ft.



△ B D3874-1LXX FLOOR PROTECTOR



△ B D3874-2LXX FLOOR PROTECTOR

u/b, 24684

RELEASED
2014-06-17
mp

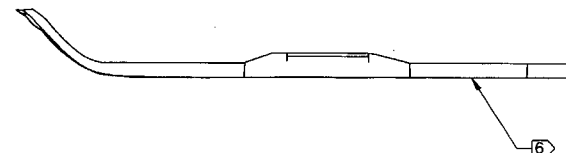
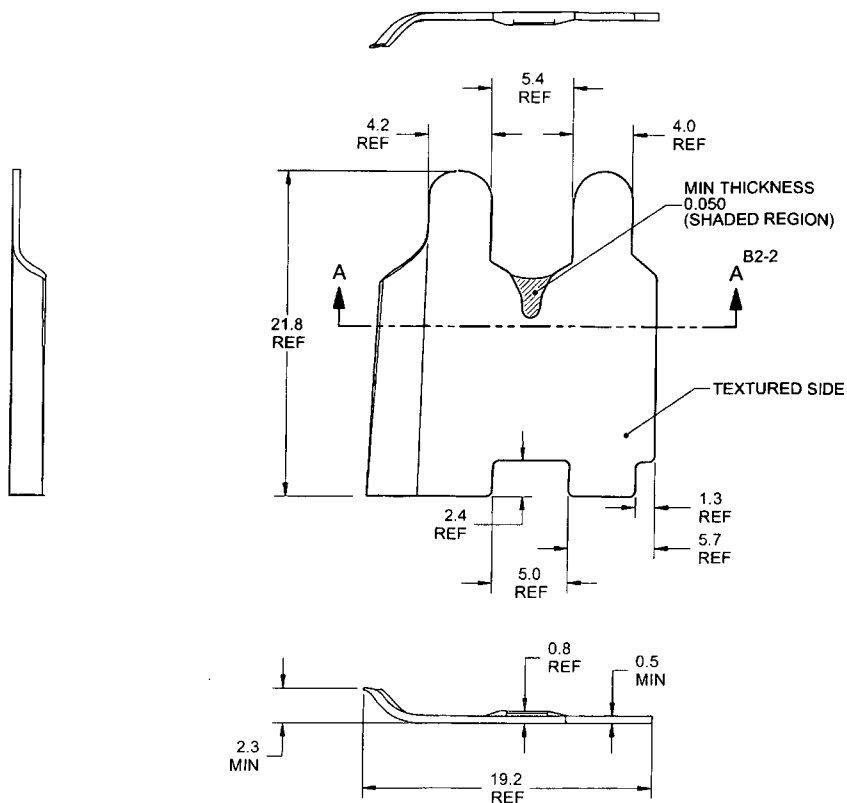
APPROVED	DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	AK		
	CHECKED	RF	DRAWING NO.	REV. B
	MFG. APPR.	DL	D3874	SHEET 1 OF 3
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	FLOOR PROTECTOR	NTS
	DATE	14.04.10	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

D

C

B



SECTION A-A
SCALE 2X

C5-2

D3874-1LXX FLOOR PROTECTOR

RELEASED
2014-06-17

NOTES:

- 1) MATERIAL: SEE TABLE **B**
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-1LXX" USING VIBRATING STYLUS
- 7) WEIGHT: 1.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.065" ELSEWHERE EXCEPT AS SHOWN

B

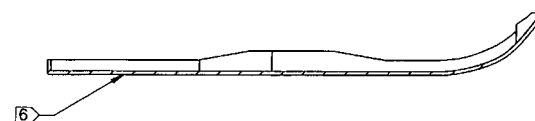
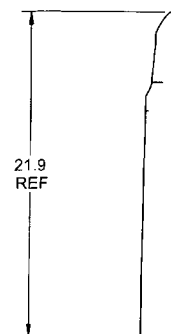
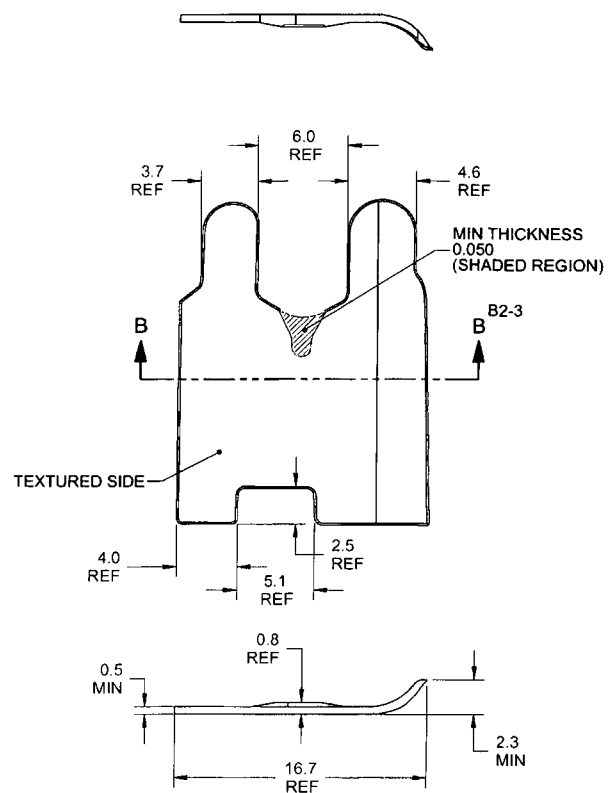
PART NUMBER	DESCRIPTION
D3874-1L02	F6006 SUEDE/POLISHED 701 BLACK LEXAN SHEET 0.125 THICK (REF DART SPEC MLEX.125-F6006-02)
D3874-1L08	90318 PROTECT-A-GLAZE 112 CLEAR LEXAN SHEET 0.118 THICK (REF DART SPEC MLEX.118-90318-08)

APPROVED

DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	DL	D3874	SHEET 2 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	FLOOR PROTECTOR	NTS
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



SECTION B-B
SCALE 2X

D3874-2LXX FLOOR PROTECTOR

RELEASED
2014-06-17

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-2LXX" USING VIBRATING STYLUS
- 7) WEIGHT: 1.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.055" ELSEWHERE EXCEPT AS SHOWN

B

PART NUMBER	DESCRIPTION
D3874-2L02	F6006 SUEDE/POLISHED 701 BLACK LEXAN SHEET 0.125 THICK (REF DART SPEC MLEX.125-F6006-02)
D3874-2L08	90318 PROTECT-A-GLAZE 112 CLEAR LEXAN SHEET 0.118 THICK (REF DART SPEC MLEX.118-90318-08)

APPROVED

DESIGN	AK	DART AEROSPACE LTD	
DRAWN	AK	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	DL	D3874	SHEET 3 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	FLOOR PROTECTOR	NTS
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8 7 6 5 4 3 2 1

DQA:

Date: 14/12/08



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 14/12/08

Work Order update only ☐

Work Order: <u>124684</u>	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input checked="" type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D30742-02</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input checked="" type="checkbox"/>
NCR No. <u>14-4364</u>		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design		14/09/23	110	1	Add textured bottom as per customer requirement Design change	DAS 12 9-89 14/09/27	OK use as is, per D.S. email	Jh 14/09/23	S 14/10/02	S 14/10/02
Doc/Data										
Equip/Tooling										
Handling/Pre										
Material										
Operator										
Offset/Setup										
Process										
Supplier										
Training										
Transport										
Unapproved										

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input checked="" type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Chris Provencal

From: David Shepherd
Sent: Friday, August 29, 2014 12:23 PM
To: Peggy McDonald; Bill Beckett
Cc: Sam Summers; Sian Willems; Nigel Forbes; Chris Provencal; Mike Petsche
Subject: RE: BLACK textured floor protector - FYI

Peggy,

The part number will not be changing for this trial. So, if he's putting this into a 407, I believe the part number he needs is D407-781-025L02 per DSI 9695. If John is happy with it, we will need to decide whether the textured version becomes the standard or whether we create a separate part number. I know Bill is leaning towards making the textured version the standard.

Bill,

Agreed ... The textured version can be signed off as deviation by Chris Provencal or Mike Petsche. We need to ensure that the texture doesn't interfere with the installation.

Regards,
David

From: Peggy McDonald
Sent: August-29-14 10:03 AM
To: Bill Beckett; David Shepherd
Cc: Sam Summers; Sian Willems; Nigel Forbes
Subject: RE: BLACK textured floor protector - FYI

We will need a P/N

From: Bill Beckett
Sent: Friday, August 29, 2014 12:02 PM
To: Peggy McDonald; David Shepherd
Cc: Sam Summers; Sian Willems; Nigel Forbes
Subject: Re: BLACK textured floor protector - FYI

Peggy - Great, can you get a an order in Intuitive and we will proceed.
David - just sign off in a deviation?
Bill

Sent from my iPhone

On Aug 29, 2014, at 11:56, "Peggy McDonald" <pmcdonald@dartaero.com> wrote:

Textured please. (forgot to include in the email)

From: Bill Beckett
Sent: Friday, August 29, 2014 11:55 AM
To: Peggy McDonald